

• **Work Order ID 80053**

February-09-12 12:39:37 PM

80053

Page 1

ASAP

Item ID: D2600-3-120

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Extrusion Round 3" 350

Start Date: 09/02/2012 Start Qty: 80.00

80

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: *M.L.J*

Date: *12/02/09* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2600

E

100

PURCHASING

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: *1444*

a) Extrude as per Dwg D2600 (120" long)

b) Material: 6061-T6

c) Material certification is required.

12-02-9
80

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

12/2/23
78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80053

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February-09-12 12:39:37 PM

Item ID: D2600-3-120 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Extrusion Round 3" 350
 Start Date: 09/02/2012 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 23/02/2012 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester								
130	Identify as per dwg & Stock Location:	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

5/26/12

5/2/12

* Full 27 x15 PCS to QC inspection *
 LANDING GEAR

7/12-3.6

12/3/12

012-03-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February-09-12 12:39:42 PM

Page 1

Work Order ID: 80053

80053

Parent Item: D2600-3-120

D2600-3-120

Parent Item Name: Extrusion Round 3" 350

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D: 02.09.10 Added DSK 066 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120P		Purchased	No			110	Each	0.0000	1	80			
D2600-3-120P									**				
Extrusion Round 3" 350													

4/2/2012 (72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
 MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
 D2600-1 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MH-18870
 - SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
 D2600-3 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MH-18859
 - SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
 D2600-5 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
 D2600-7 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MS-18872

COPY
 PRINT

80053 M.C.T
 12/02/09

RELEASED
 2012-01-11

E	REFORMAT DWG: ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS: ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2600
 TITLE EXTRUSION
 REV. E
 SHEET 1 OF 3
 SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

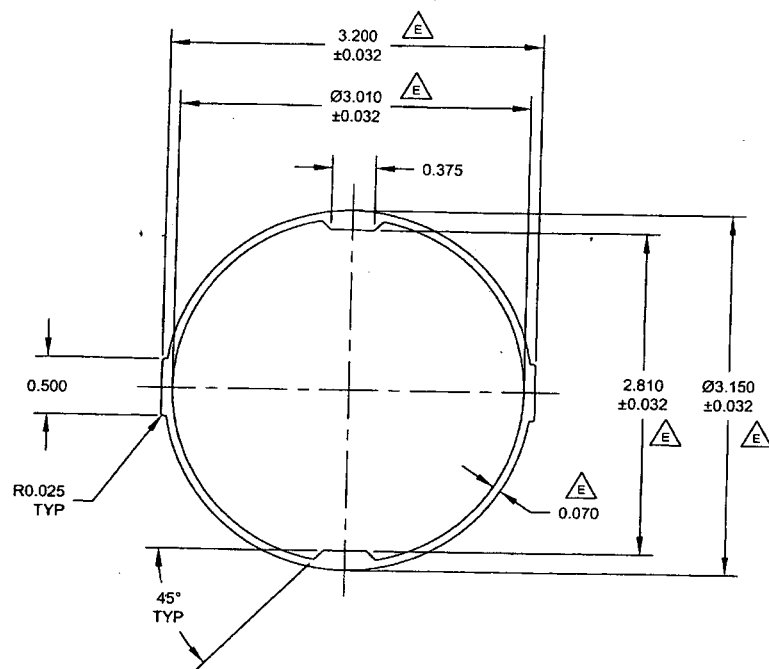
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

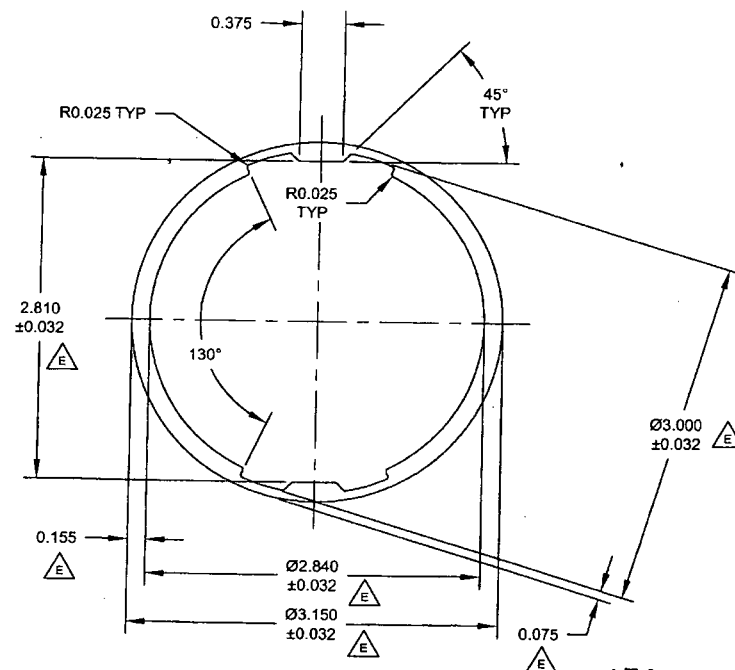
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80053



D2600-1 EXTRUSION



D2600-3 EXTRUSION

RELEASED
2012-01-10

DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	E	D2600	SHEET 2 OF 3
APPROVED	WAP	TITLE	SCALE
DE APPR.		EXTRUSION	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

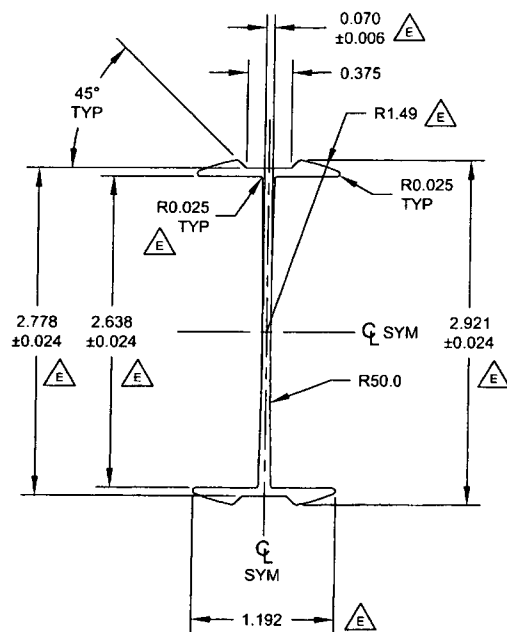
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

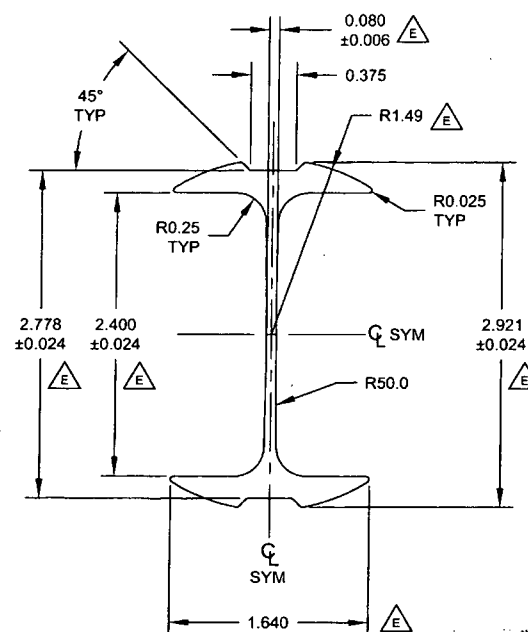
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80053



D2600-5 EXTRUSION



D2600-7 EXTRUSION

RELEASED
2012-01-11
11/11

DESIGN	4	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	EL	D2600	SHEET 3 OF 3
APPROVED	#	TITLE	SCALE
DE APPR.	#	EXTRUSION	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16161

Purchase Order Date 2/9/2012
PO Print Date 2/10/2012

Page Number 1 of 2

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name
Vendor Phone 800 563 1079
Vendor Fax 800 565 8339
Vendor Account Nbr

Buyer Brigitte Golden
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CX 2/10/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2600-3-120P	Extrusion Round 3" 350	2/29/2012 Yes	80.00 Each	Yours ppd	\$46.6380	\$3,731.04
Special Inst:			As per DWG: D2600 Rev: E B80053 6061-T6 as per (QQ-A-200/8) MINIMUM YIELD TENSILE STRENGTH=40 KSI MINIMUM ULTIMATE STRENGTH= 40KSI MINIMUM ELONGATION = 8% 120" LONG SIGNATURE TOOL DIE # 897122				
2	D2500-1-190P	Ext'n -I' Beam Tube 4"	2/29/2012 Yes	80.00 Each	Yours ppd	\$82.9265	\$6,634.12

Change Nbr: 4

Change Date: 2/10/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

ACCT# 46024

INVOICING AND COMPANY LOCATION

SHIPPING MANIFEST

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

MANIFEST DATE / DATE DU BODEREAU
02-28-12

MANIFEST NUMBER / N° DE BODEREAU
004693

SALES ORDER NUMBER / N° DE COM
104583

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	PUP	042		G.ATTENBOROU
JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE
CARRIER / TRANSPORTEUR JODEE		G.ATTENBOROU		DLB

CUSTOMER ID / ID DU
CLIENT

46024

ORDER DATE / DE LA
COM

02/10/12

CUSTOMER PO NUMBER / CLIENT PO Nombre

PO16161

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

004693

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,279	LB		DAA-897122-1	6061 T6		2	1,274	1,221	LB	
	580	KG		D2600-3-120	120.0000 IN			578	554	KG	
	80	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: 0 % Max: 0 %			78	PC	
						810324 / 132891	1	637	611		39 PC
						810324 / 132892	1	637	611		39 PC

76

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

		Continued	
TOTALS			



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
02/26/2012	5279012	104583	1
Cust PO	B/L No	Lot	Date
PO16161	004693	810324	02/28/12

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No.	Part No	Item Description	Cust Part
001	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	1,274 LBS		
Net Qty	1,221 LBS	78 PCS	2 PKGS
Specification	AMS-QQ-A-200/8 & ASTM B221-08		
	Die Desc		

Mechanical Tests:

Tensile	Yield			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HREW</u>
325.6 / 47.2	302.8 / 43.9	11.7	0.0	96

Chemical Analysis:

<u>SI</u>	<u>FE</u>	<u>CU</u>	<u>MN</u>	<u>MG</u>	<u>CR</u>	<u>ZN</u>	<u>TI</u>	<u>V</u>
0.66	0.29	0.24	0.09	0.97	0.07	0.09	0.02	0.01

82603/02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc